

Work Order ID 69291 *Split*

Friday, May 06, 2011 11:54:12 AM

Page 1

Item ID: D3564-1

Revision ID:

Item Name: Wearshoe

Start Date: 5/6/2011 Start Qty: 12.00

Required Date: 5/9/2011 Req'd Qty: 12.00

Reference:

Approvals:

Process Plan:

QC:

Date: 11-05-11

Date:

Tooling:

SPC (Y/N):

Date:

Date:

Run Start

Stop

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D3564

Rev D

100

0.00



FLOW WATER JET

Waterjet

Memo

0.00

FLOW CNC Waterjet

1-Cut as per Dwg D3564 *****{D3564-1F}***** Dwg Rev: D Prog
Rev: D 2-Deburr if necessary

11-5-9

16

110

0.00



QC2- Inspect parts off machine FAI/FAIB

QC

Memo

0.00

Quality Control

11-5-9

120

0.00



QC8- Inspect parts - second check

QC

Memo

0.00

Quality Control

8/11/05/10

16

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 69291

Friday, May 06, 2011 11:54:12 AM



Page 2

Item ID: D3564-1

Accept



Setup Start



Revision ID:

Item Name: Wearshoe

Stop



Start Date: 5/6/2011 Start Qty: 12.00



Cust Item ID:

Required Date: 5/9/2011 Req'd Qty: 12.00



Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

130



Brake NC

Brake NC

NC BRAKE

Memo

0.00

0.00

Deburr if necessary Form on Brake as per Dwg D3564 using Jigs DT 8179 and DT 8155 Form Joggles (2) as per Dwg D3564 on brake using Jig DT 8157

SB uloslu

16

140



QC

Quality Control

QC5- Inspect part completeness to step on W/O

Memo

Ensure joggle as per dwg D3429

0.00

0.00

8 uloslu

X16

150



Large Fab

Large Fab

Large Fab

Memo

Qty Description Batch A/R 2059B Hardcoat
Weld hardcoat as per Dwg D3437

0.00

0.00

EL 11-6-28 X14

W/O:		WORK ORDER CHANGES					
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Work Order ID 69291

Friday, May 06, 2011 11:54:12 AM



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Item ID: D3564-1

Accept



Setup Start



Revision ID:

Stop



Item Name: Wearshoe

Start Date: 5/6/2011 Start Qty: 12.00



Cust Item ID:

Required Date: 5/9/2011 Req'd Qty: 12.00



Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

160

QC10- Inspect visual per QS1004- ground welds

0.00



QC

Memo

0.00

S 11/06/28

Quality Control

170

QC5- Inspect part completeness to step on W/O

0.00



QC

Memo

0.00

S 11/06/28

(114)

Quality Control

180

Grey Sandtex(Ref:4.3.5.6) per QS1005 4.3

0.00



Powdercoat

Memo

0.00

START TIME:

9:30

OVEN TEMPERATURE:

320 FINISH TIME:

10:00

Powder Coating

14 BL 11-6-29

W/O:		WORK ORDER CHANGES					
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NOTE: Date & initial all entries

Work Order ID 69291

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Page 4

Item ID: D3564-1

Accept



Setup Start



Revision ID:

Item Name: Wearshoe

Stop



Start Date: 5/6/2011 Start Qty: 12.00



Cust Item ID:

Required Date: 5/9/2011 Req'd Qty: 12.00



Customer:

Reference:

Approvals: Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

190

QC3- Inspect Part Finish

0.00



QC

Memo

0.00

Quality Control

14 6 11/06/29

200

Identify as per dwg & Stock Location FP-70

0.00



Packaging

Memo

0.00

Packaging

12 6 11/06/29

210

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

11/6/30 11/06/29

W/O:		WORK ORDER CHANGES					
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NOTE: Date & initial all entries

Picklist Print

Friday, May 06, 2011 11:54:19 AM

Page 1

Work Order ID: 69291



Parent Item: D3564-1



Parent Item Name: Wearshoe

Start Date: 5/6/2011

Required Date: 5/9/2011

Start Qty: 12.00

Required Qty: 12.00

Comments: IPP Rev:A New Issue 07-03-08 ec
 IPP Rev:B As per Rev C 07-07-09 JLM
 IPP Rev:C As per Rev D 07-09-09 JLM Verified By:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

M304S16GA

Purchased

No

100

sf

98.5000

1.41

17.81053

22.6



1611-5-9

3047316 Sheet .063

Location

Loc Qty

Loc Code

MAT020

98.5

117275

98.5

117275

118

W/O:		WORK ORDER CHANGES					
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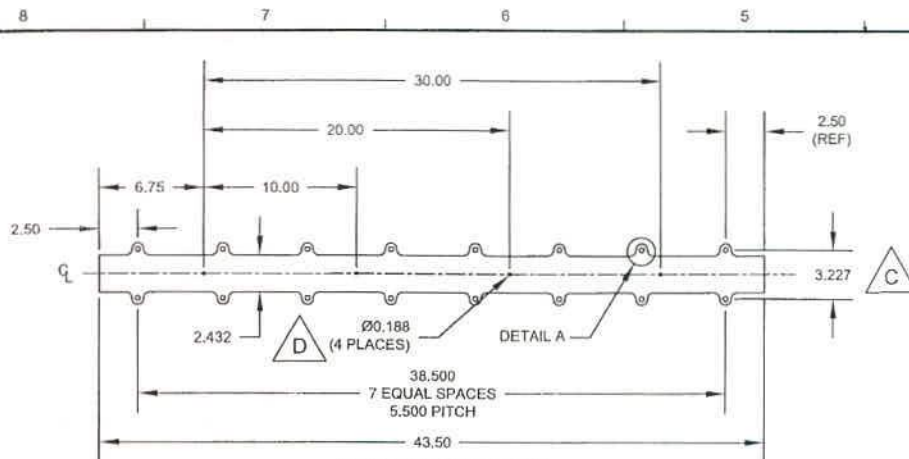
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DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

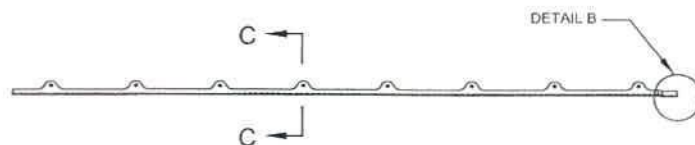
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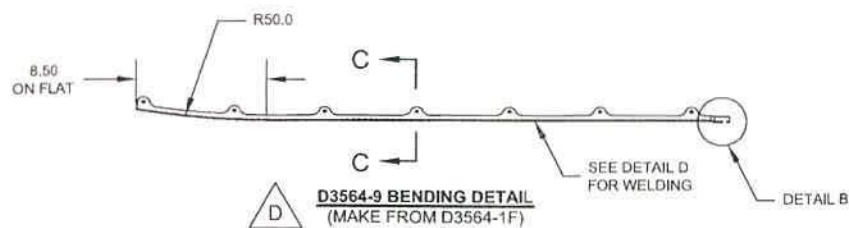
NOTE: Date & initial all entries



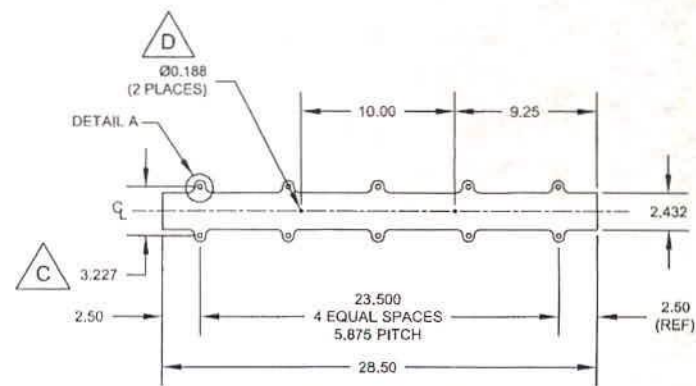
D3564-5F FLAT PATTERN



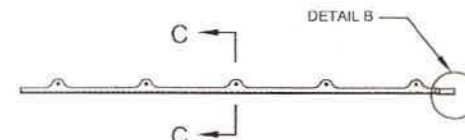
D3564-5 BENDING DETAIL
(MAKE D3564-5 FROM D3564-5F)



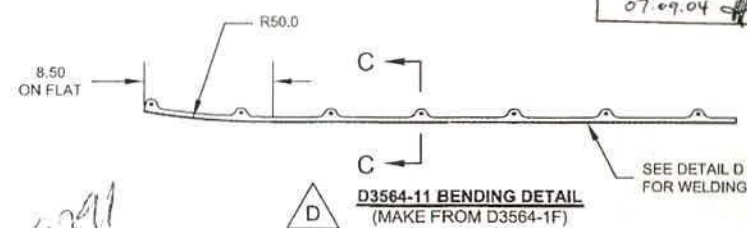
D3564-9 BENDING DETAIL
(MAKE FROM D3564-1F)



D3564-7F FLAT PATTERN



D3564-7 BENDING DETAIL
(MAKE D3564-7 FROM D3564-7F)



D3564-11 BENDING DETAIL
(MAKE FROM D3564-1F)

RELEASED
07.09.04

u/b 64241

DESIGN	PH	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	CB		
CHECKED	PH	DRAWING NO.	REV. D
MFG. APPR.	PH	D3564	SHEET 2 OF 3
APPROVED	PH	TITLE	SCALE
DE APPR.	PH	WEARSHOE	1:8
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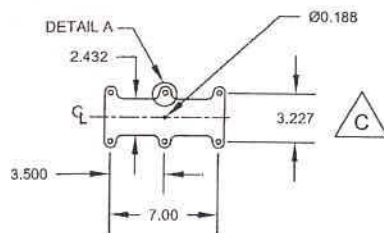
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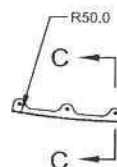
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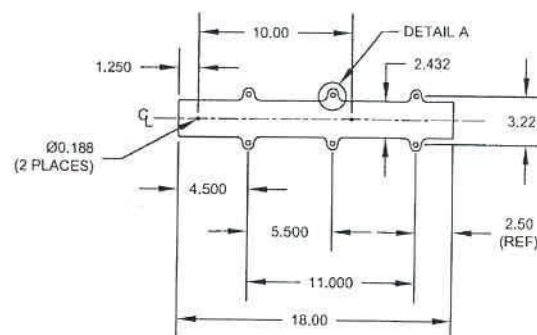
NOTE: Date & initial all entries



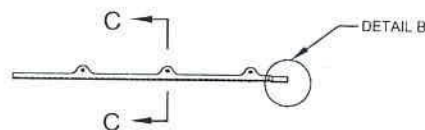
D3564-13F FLAT PATTERN



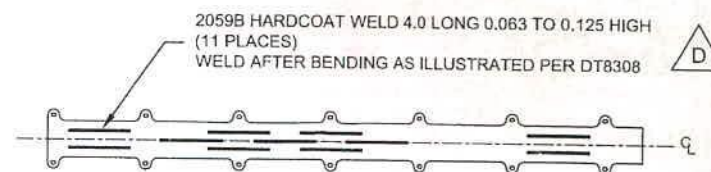
D3564-13 BENDING DETAIL
(MAKE D3564-13 FROM D3564-13F)



D3564-15F FLAT PATTERN

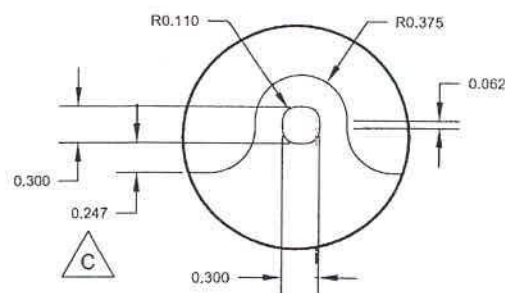
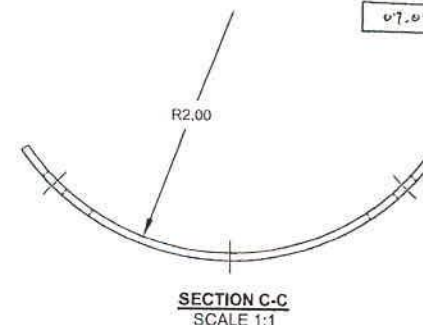


D3564-15 BENDING DETAIL
(MAKE D3564-15 FROM D3564-15F)

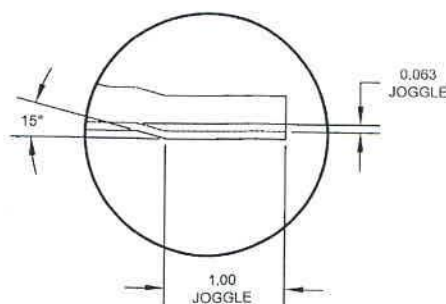


DETAIL D
(D3564-1/-3/-9/-11 WELDING DETAIL)

RELEASED
07.09.04



DETAIL A
SCALE 1:1



DETAIL B
SCALE 1:1

DESIGN	PH	DART AEROSPACE LTD	
DRAWN	CB	HAWKESBURY, ONTARIO, CANADA	
CHECKED	PH	DRAWING NO.	REV. D
MFG. APPR.	PH	D3564	SHEET 3 OF 3
APPROVED	PH	TITLE	SCALE
DE APPR.	PH	WEARSHOE	1:
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